

Date: Wednesday, 3/12/2008 1:59:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 37892	
Estimate Number : 12393	
P.O. Number :	Part Number : D33531
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30453	Material :
Written By :	Due Date : 4/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>1908 03 12</u>	
Comment : est rev: A 06.04.24 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1018B400X250	Inventory
-----	---------------	-----------



6.5



Comment: Qty.: 0.5250 f(s)/Unit Total : 0.5250 f(s)

1010-1025 BAR

105358 B 8-3-24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: A

Prog Rev: A

B 8-3-24

2-Deburr

B 8-3-24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-3-24



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------




Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 485.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:59:01 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 37892

Part Number: D33531

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

1208127

Job Completion



u 08-03-26

8 9 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

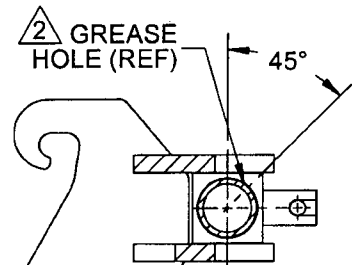
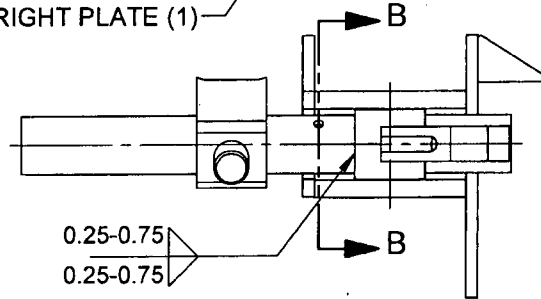
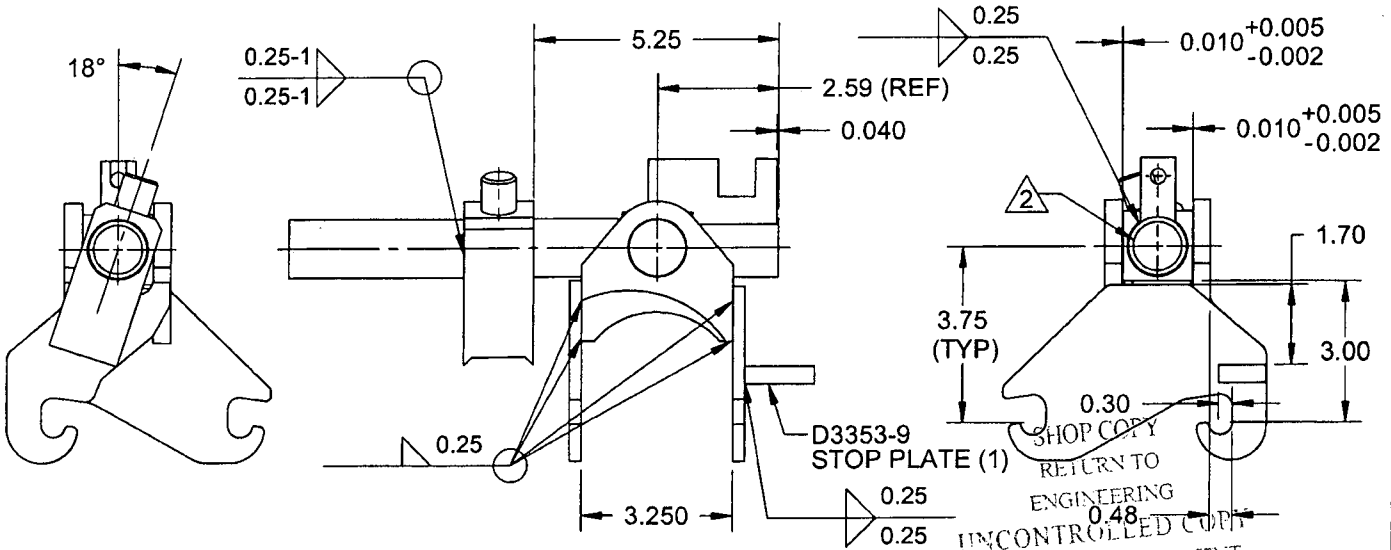
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

RELEASED
06/03/59

D3353-11 UNIVERSAL JOINT (1)
D3357-5 BACK PLATE (1)
D3353-17 SUPPORT (1)
D3353-13 TUBING (1)
D3353-3 RIGHT PLATE (1)
D3353-15 LOCK BRACKET (1)
D3353-7 FRONT PLATE (1)
D3353-1 LEFT PLATE (1)

**SECTION B-B****D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

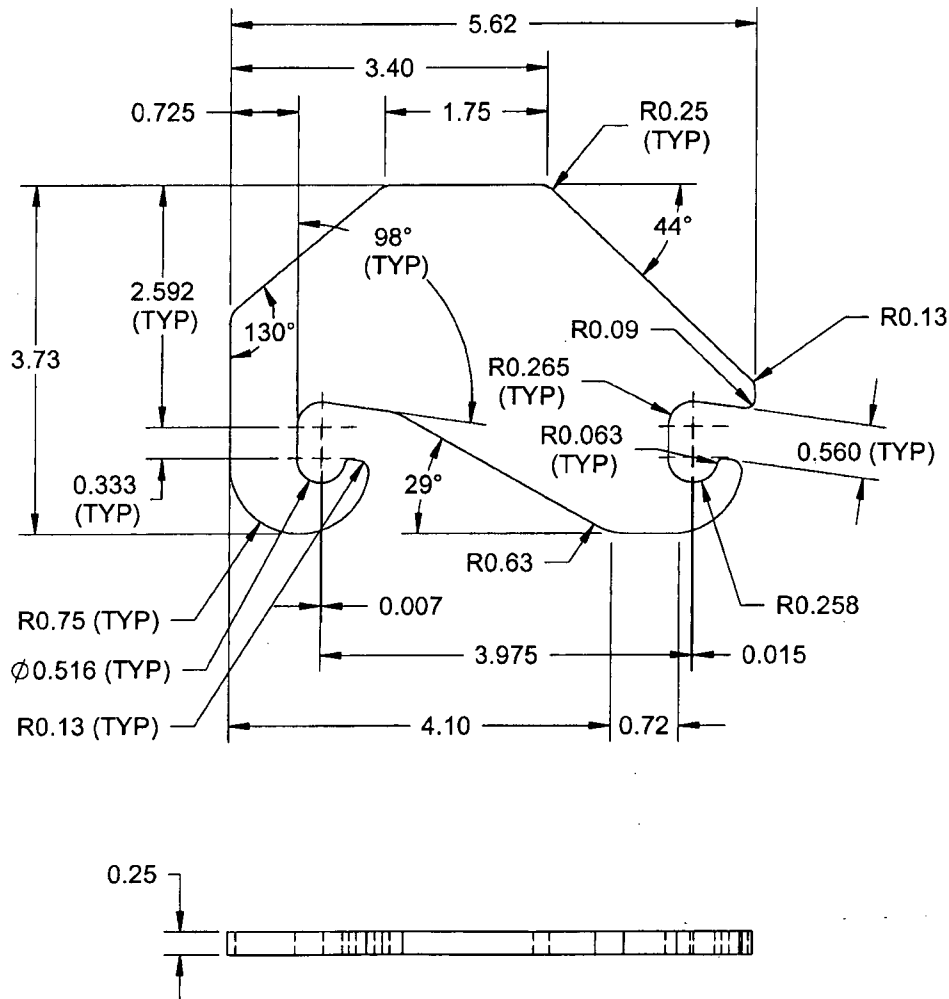
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:2

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[Signature]
01/07/14**D3353-1 LEFT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

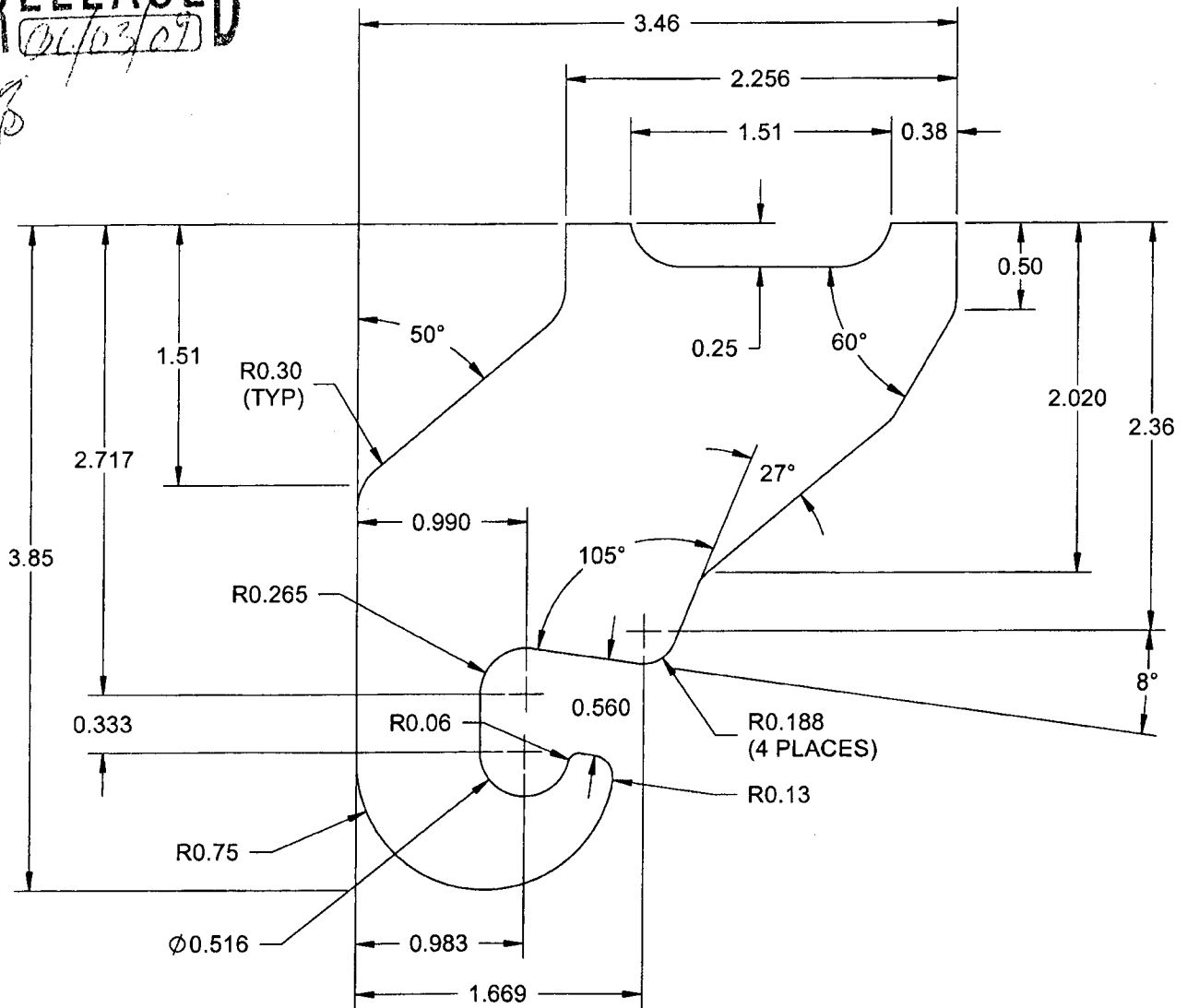
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
01/03/09**D3353-3 RIGHT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

0.25
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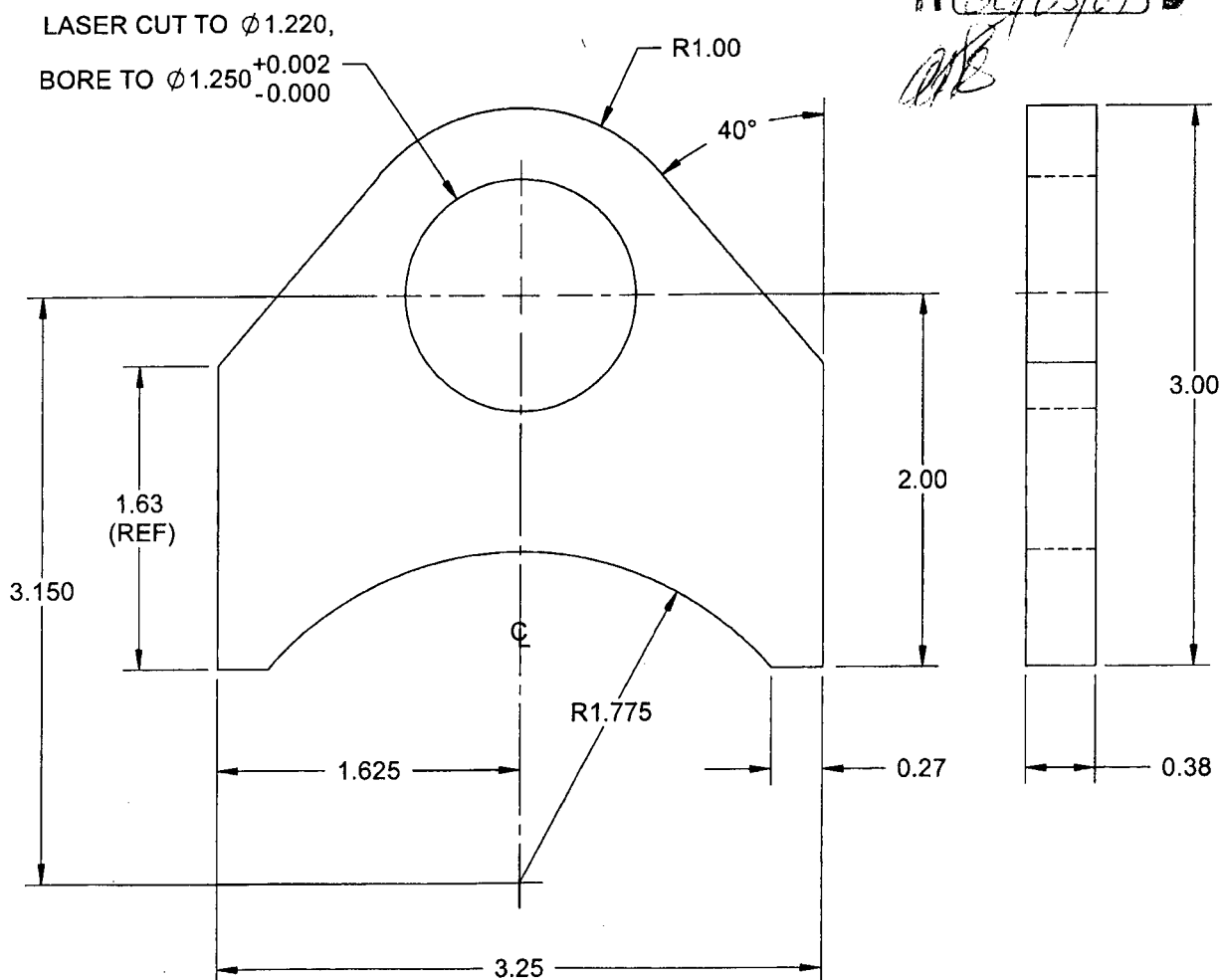
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
06/03/09



D3353-5 BACK PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

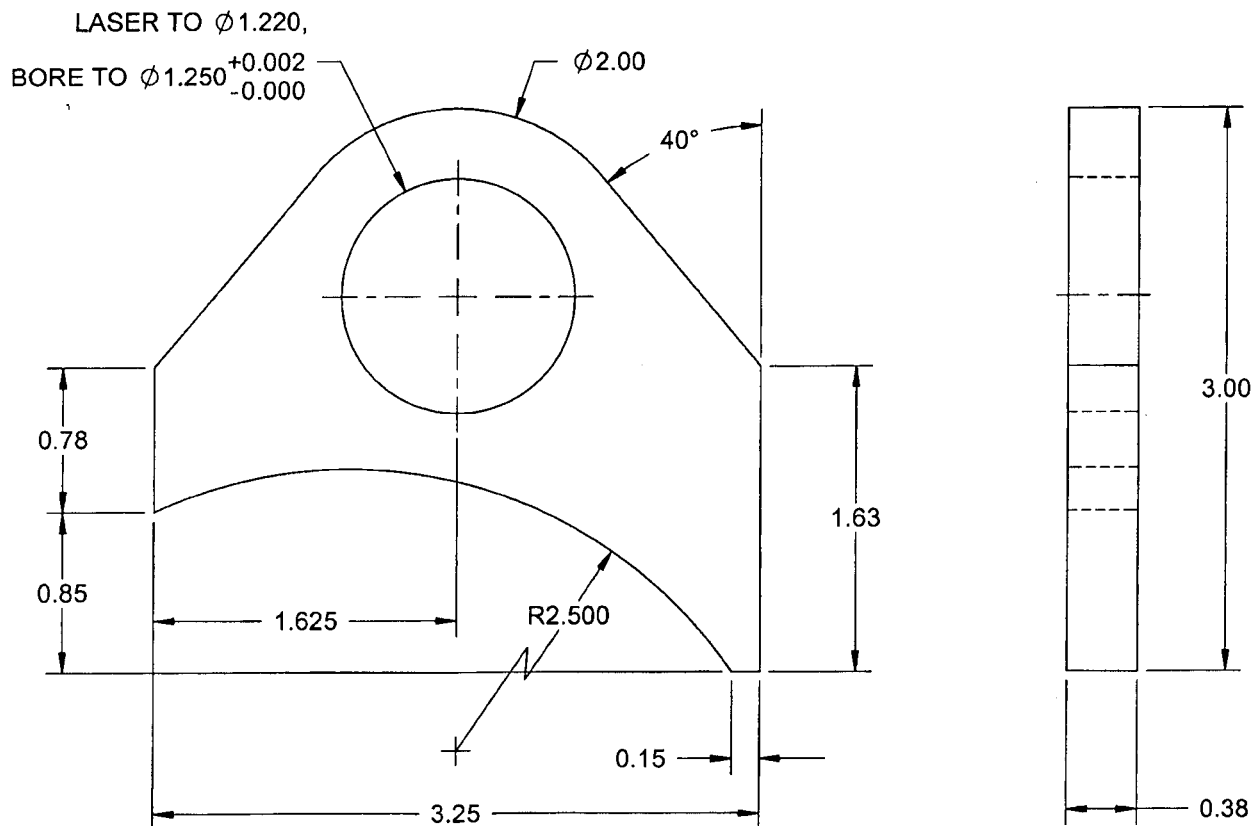
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DATE 04.12.14		TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1

RELEASED
(06/03/07)**D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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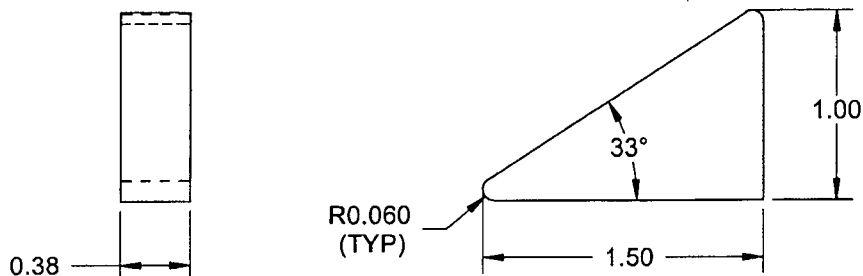
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

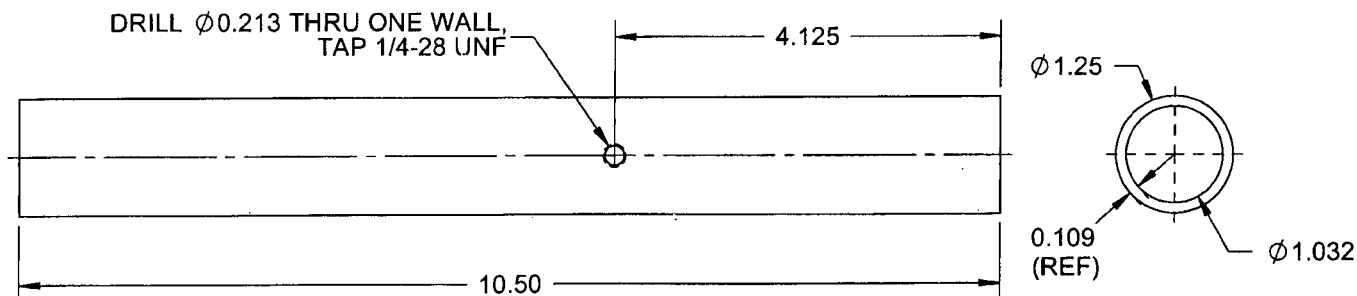
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D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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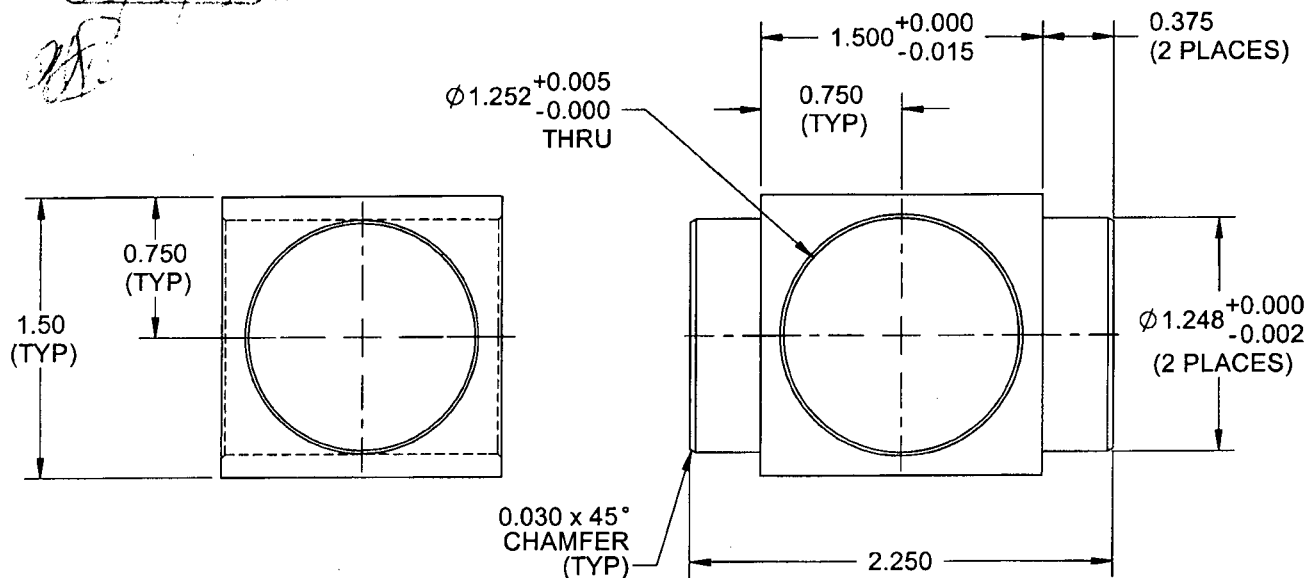
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04/33/09



D3353-11 UNIVERSAL JOINT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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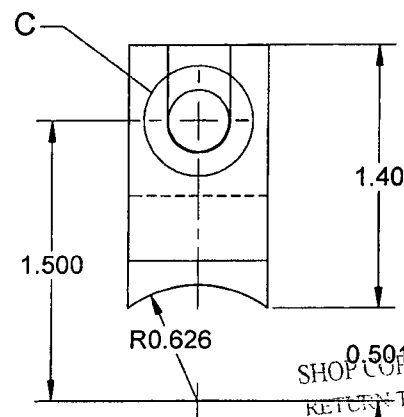
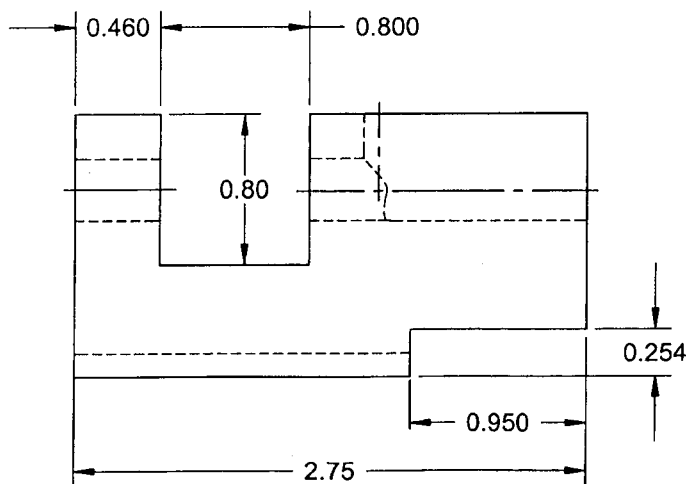
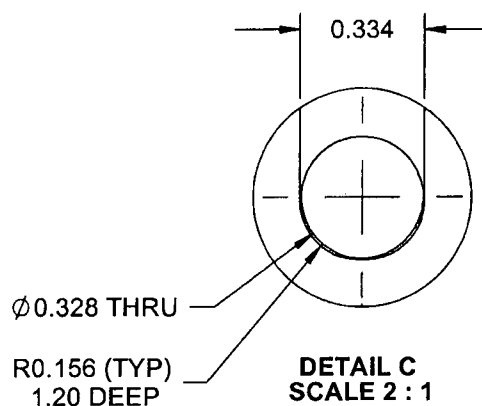
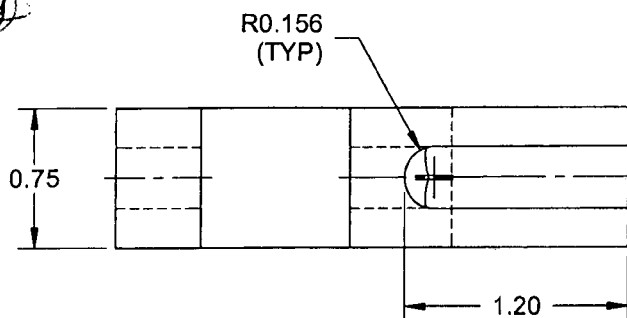
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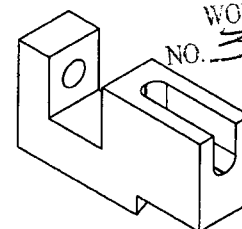


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D3353-15 LOCK BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



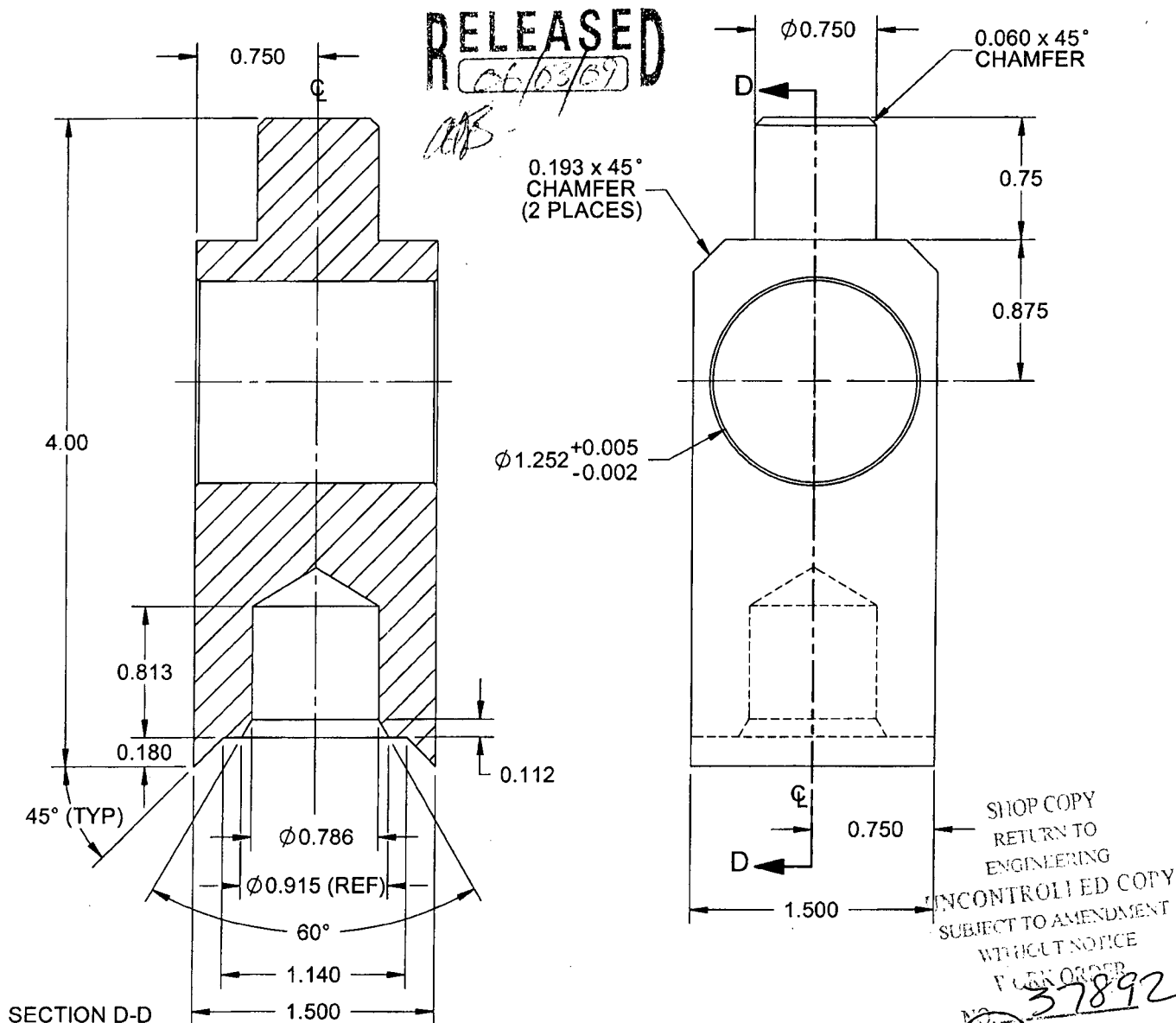
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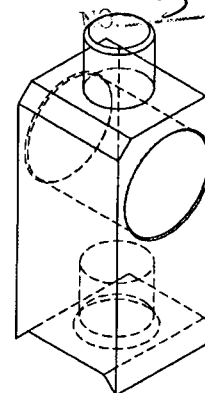
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1



D3353-17 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
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- 3) ALL DIMENSIONS ARE IN INCHES
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